

Date: Thursday, 11/16/2006 4:25:31 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 29488		Part Number	: D25771		
Estimate Number	: 10288		Drawing Number	: D2577 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/16/2006 S.O. No. : N/A		Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/5/2006		
Previous Run	: 28063		Qty:	50	Um:	Each
Written By	: <u>ML</u> 06/11/07					
Checked & Approved By	: <u>ML</u> 06/11/07					
Comment	: Est: E 02.09.24 Re-format; Incorporated D2577-101-11KJ/ RF est F 06.09.11 now waterjet EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
Comment: Qty.: 0.8474 sf(s)/Unit Total: 42.3675 sf(s) 43.2148 1010/1025/A21/6aA SHEET <u>M102684</u> <u>ML 06/11/21</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2577 (D2577-101 detail) Dwg Rev: <u>E</u> <u>ML 06/11/24</u> 50 Prog Rev: <u>E</u>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 50		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 50		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form on brake as per Dwg D2577 using DT8155 and DT8179 2-Form joggle as per Dwg D2577 using DT8157 3-Identify as D2577-1 4-Deburr if necessary <u>SB 06/11/27</u> 50		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/02
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/16/2006 4:25:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 29488

Part Number: D25771

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/06/11/29 (50)

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

MF 06-12-19 (50)

Qty

Description

Batch

A/R 7560 Hardcoat Rod

m102756, m102154, m102885

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/06/12/19 (50)

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

a.m

06/12/20

fo

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



yl



06/12/21 (50)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP

yl

06/12/28

12.0 QC21

FINAL INSPECTION/W/O RELEASE



4P 06/01/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



a 06/12/29

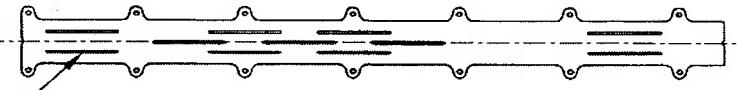
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

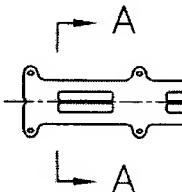


D2577-1 & D2577-3 WEARSHOE

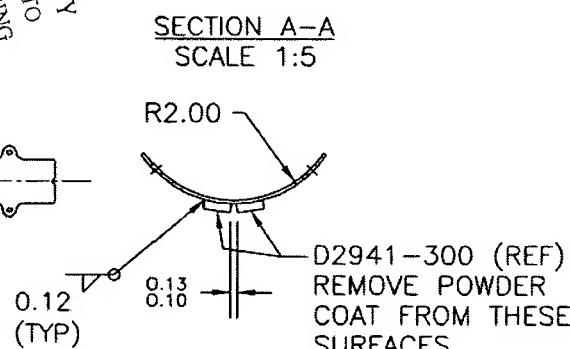
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



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D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
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Dart Aerospace Ltd.

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CHECKED	APPROVED	DRAWING NO.
		D2577
00.09.22		DATE SHEET 1 OF 5
A	96.09.16	NEW ISSUE
B	96.12.04	ADD HARDCOAT WELDS
C	97.05.30	CHANGE HOLES TO O'BROUNDS
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176
		SCALE 1:10

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Technical drawing showing a horizontal structure with the following dimensions and features:

- Width: 36.000
- Height: 3.182
- Radius: R0.128 (2 PLACES) at the top left corner.
- Width of the top horizontal part: 24.000
- Width of the bottom horizontal part: 18.000
- Width of the central vertical section: 12.104
- Width of the top vertical section: 6.000
- Width of the bottom vertical section: 30.000
- Height of the top vertical section: 2.50
- Height of the bottom vertical section: 2.43
- Text: SEE DETAIL B ON PAGE 5, located in the top center.
- Reference: (REF) 2.43, located on the right side.

D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

8.50 →
ON FLAT

R50.0

SEE DETAIL C ON PAGE 5
FOR D2577-11 ONLY

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Subject to amendment
Without notice
Work order
No. 29488

D2577-11 & D2577-13 LONGITUDINAL BEND

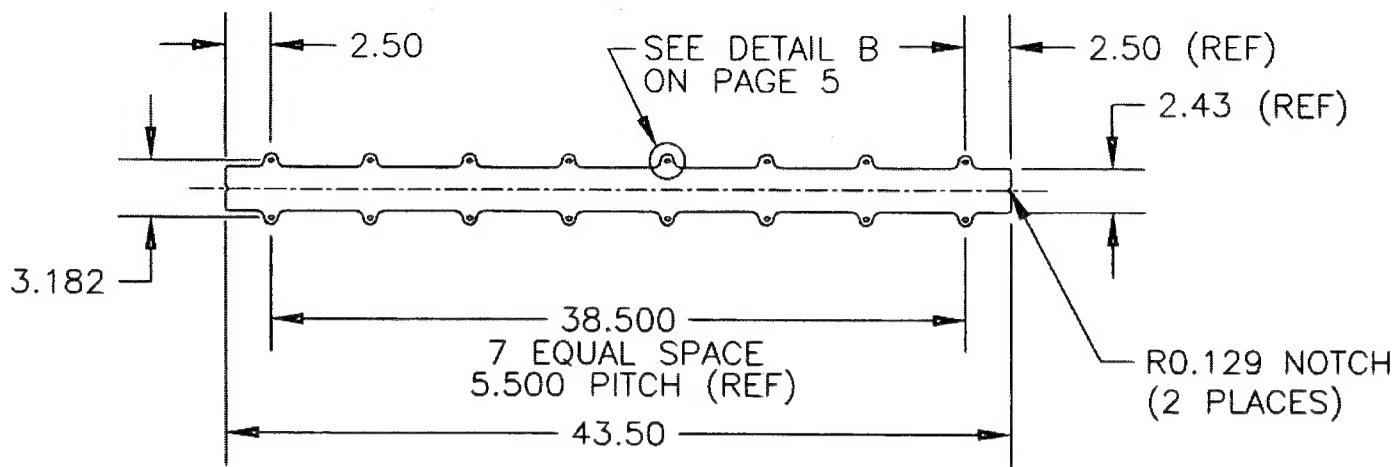
MAKE FROM D2577-101

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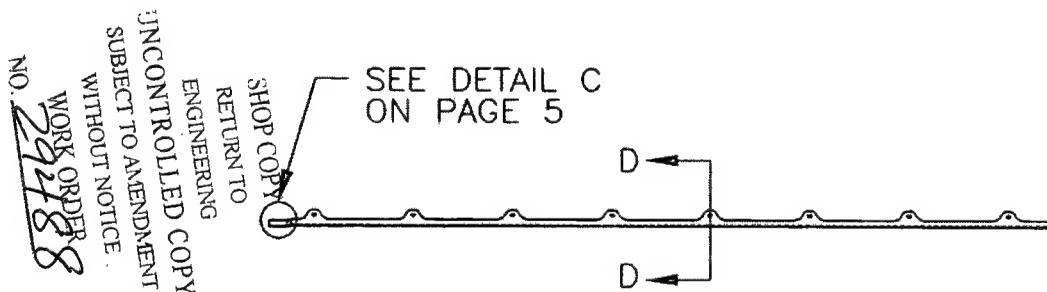


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CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO.	SHEET 2 OF 5
		D2577	
DATE	TITLE	SCALE	
		1:10	
00.09.22		WEARSHOE	

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
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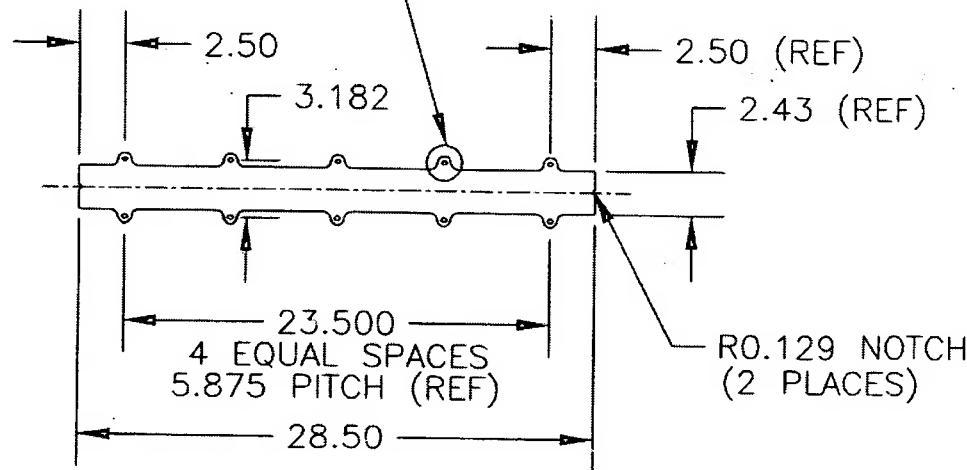
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00.09.22
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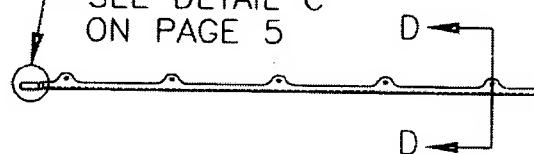
D2577-7 FLAT PATTERN

SEE DETAIL B
ON PAGE 5



D2577-7 LONGITUDINAL BEND

SEE DETAIL C
ON PAGE 5



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

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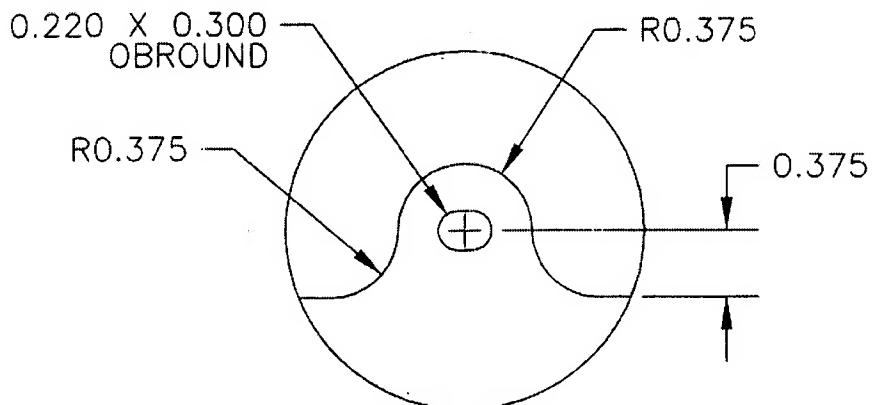
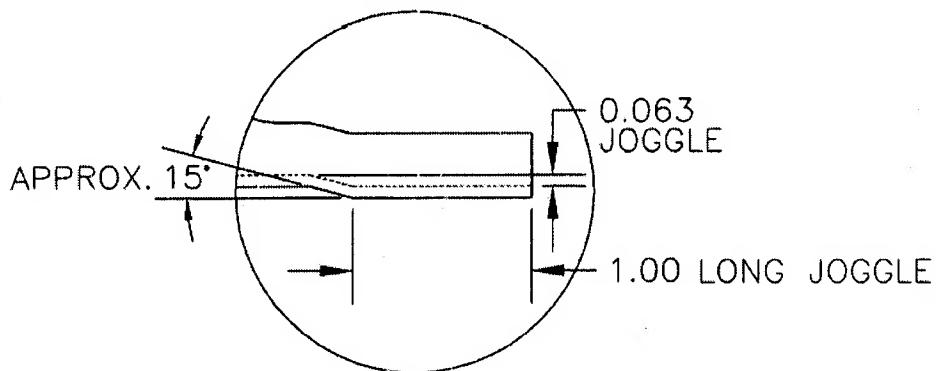
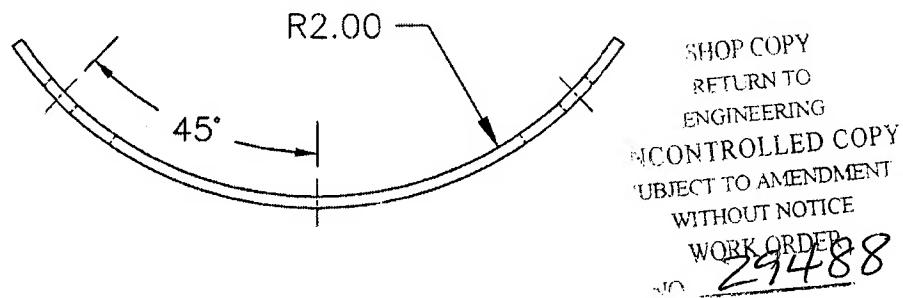
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		TITLE WEARSHOE

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SHEET 5 OF 5
1:10DETAIL B (SCALE 1:1)**RELEASED**
00.09.20DETAIL C (SCALE 1:1)SECTION D-D (SCALE 1:1)

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